

Work Order ID 83200

Tuesday, May 29, 2012 8:55:13 AM

83200

Page 1

Item ID: D3255-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Access Panel Assembly
 Start Date: 4/13/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 4/24/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *12-05-29* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3255	Rev B								

100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD								
	Batch: <i>m114509</i> 2-Grind Welds Flush								

110	QC10- Inspect visual per QSI004- ground welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4

12-05-31
/PL

PTO

S.12/15/31

(74)

S.12/15/31

(74)
-012

W/O: 83200		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3255-3 PAR #: _____ Fault Category: Weld FAB (welding) NCR: Yes No DQA: 12/06/11 Date: 12/06/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/6/12

NCR: 12-1494		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/31	#100	Qty +2 D3255-3 scrap. welder Formed them too small. not able to fit in D3255-1/2 L.L. Hammer error / low	S AS2012 12/05/31	Scrap + Destroy Qty x2 D3255-3. Replac D3255-3 B 83201	1/3L 12-05-31	S 12/05/31	S AS2012 12/05/31	S 12/05/31

NOTE: Date & initial all entries

Work Order ID 83200

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Item ID: D3255-042

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Access Panel Assembly

Stop ***NS2***

Start Date: 4/13/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: M 1166644X 12/06/044 x 6 12/06/044 12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3255-042 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 4/13/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/24/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				44			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>176</u> Memo	0.00 0.00				40		12/6/08	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/6/11 JG

MF
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83200
Parent Item: D3255-042
Parent Item Name: Access Panel Assembly

Start Date: 4/13/2012
Start Qty: 2.00
Required Date: 4/24/2012
Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-5 Gasket		Manufactured	No			100	Each	16.0000	1	2	(2)	FF	

12-06-05

Location	Loc Qty	Loc Code
GA	16	
72118	1	
75083	1	
80183	2	
83478	12	

2
2

D3255-2 x 4 #78975- MF 12-05-29
D3255-3 x 4 #83201 MF 12-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

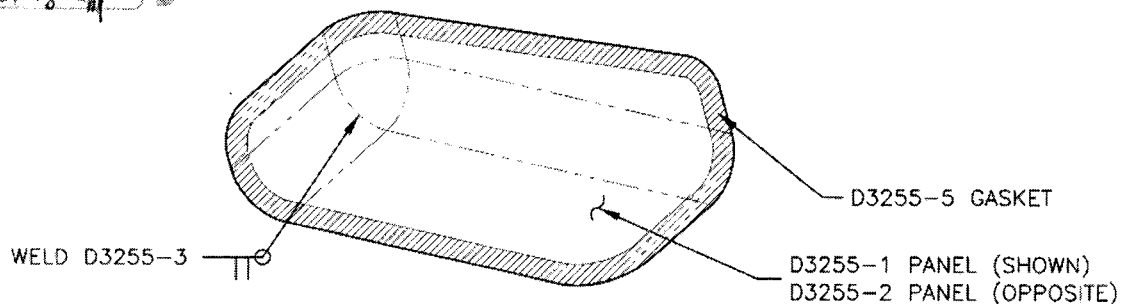
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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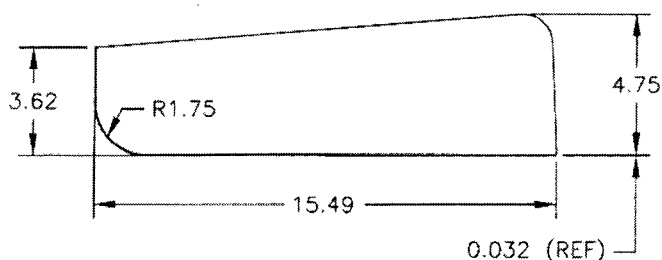
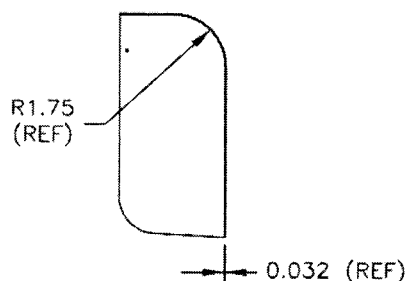
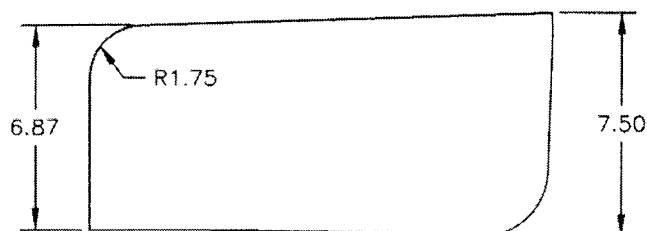


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

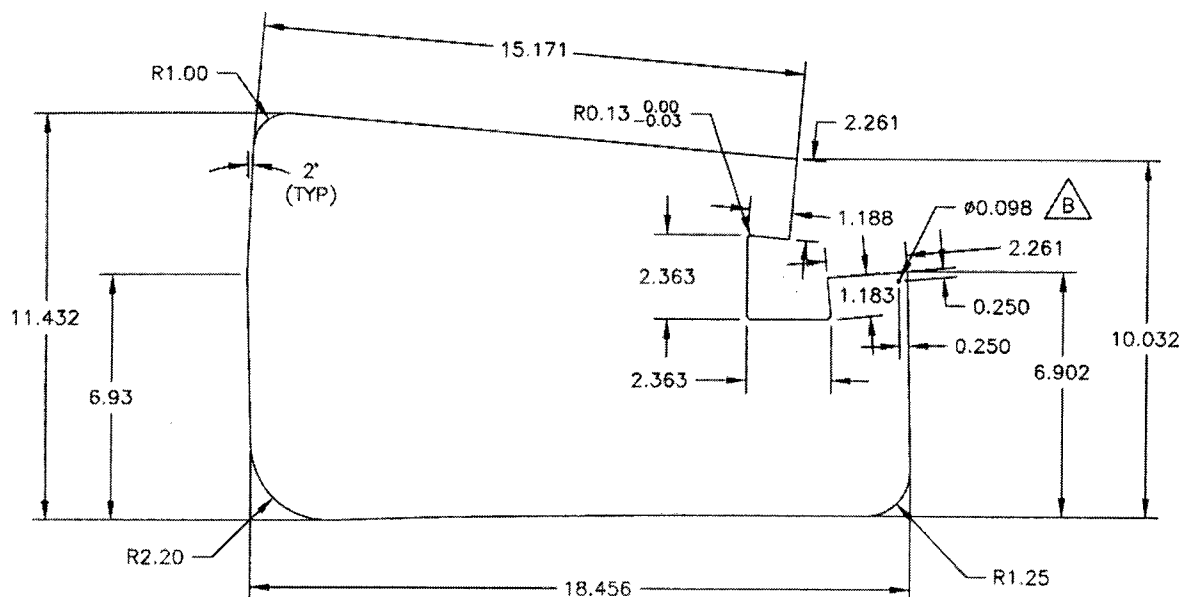
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

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05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

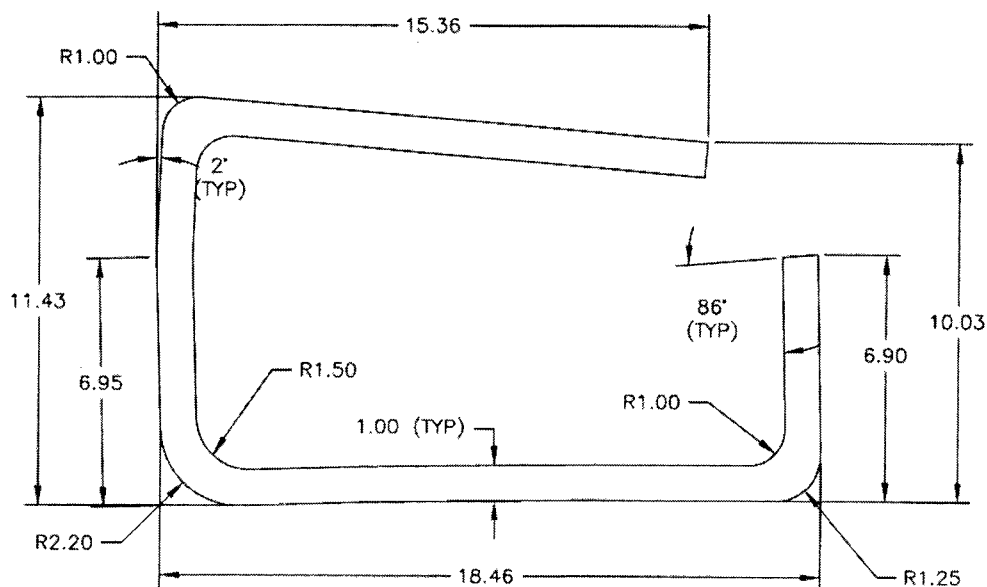
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 #



00000

D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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